



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4681-041

Job Sheet 171431



Part No: D4681-041

Job Qty: 4 ea

Part Name: Web Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,2 IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB1 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	2/15/18	2/15/18	0.00	0.00	Start Up Skid tubes-2		S.Y.
110	Skid tubes	4 pcs	2/15/18	2/15/18	0.00	3.45	Skid tubes-2		S.Y.
120	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC8 QC5		BE
121	CNC Vertical Machining	4 pcs	2/15/18	2/15/18	0.18	2.63	HAAS1-5		K 18-02-15
122	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC2 Machining-3		K 18-02-15
123	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC8 Machining-3		K 18-02-15
130	HandFinish	4 pcs	2/15/18	2/15/18	0.00	1.12	HandFinish1		18-02-15
140	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC7-4		JW
150	Skid tubes	4 pcs	2/16/18	2/16/18	0.00	3.45	Skid tubes-3		JW
160	QC	4 pcs	2/16/18	2/16/18	0.00	0.00	QC5		BE
170	Packaging	4 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3-2		BE
180	QC21-SA	4 Ea	2/16/18	2/16/18	0.00	0.00	QC21		21 APR 03 2018

Part Op 110 - 1- CUT TO LENGHT AS PER DWG

Descriptions: 121 - MILL AS PER DWG AND FOLIO FB186 DWG REV: _____ FOLIO REV: _____ DEBURR
150 - INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R
PROSEAL: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	4 Ea (1 ea)	90-Start up Operation	
D4681-3	Doubler	8 Ea (2 ea)	150-Skid tubes	
MS20470AD4-6	Rivet, Universal Head	356 Ea (89 ea)	150-Skid tubes	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2963-125 3x B115870	4	146	0
150-Skid tubes	D4681-3 F128552	8	18	0
	MS20470AD4-6 FM137851 x 31	356	884	0
	5041165 x 286			

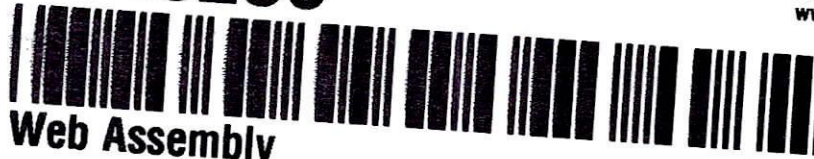
Part Specifications

Specifications could not be found.

Plex 2/1/18 10:43 AM Dart.Gagnon.Michelle

DART
AEROSPACE
S040236

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www.dartaerospace.com



Web Assembly

PART NO: D4681-041
Original Serial #: S040236
Revision:
Operation:
Change No:

Start up Operation 02/07/18
Job No: 171431

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

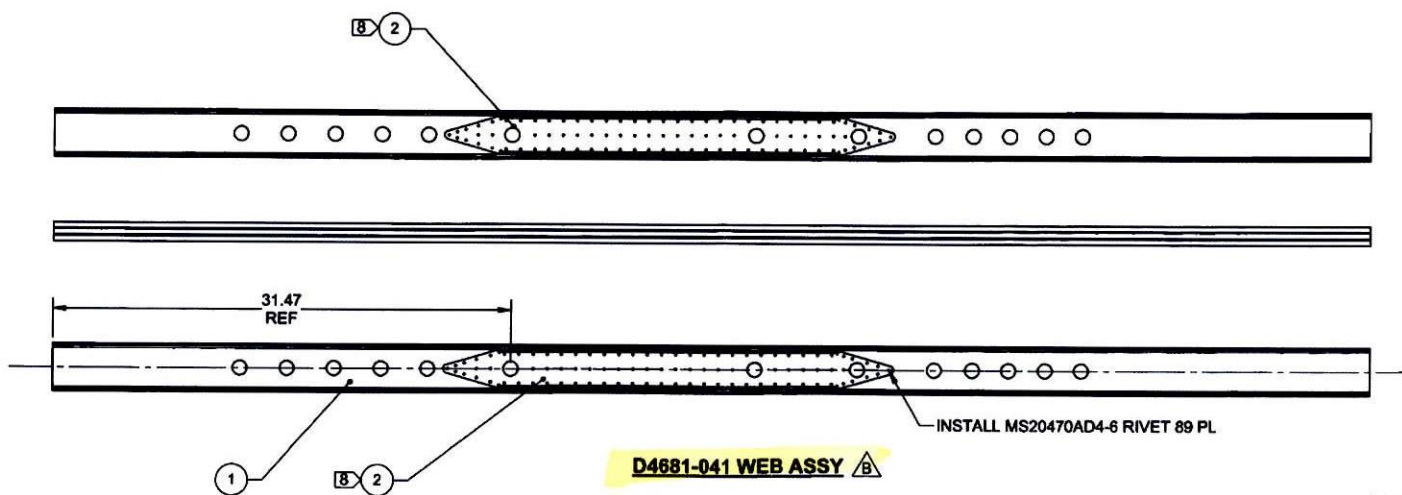
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM	QTY	P/N	DESCRIPTION
	X	D4681-041	WEB ASSY
1	1	D4681-1	WEB
2	2	D4681-3	DOUBLER
3	89	MS20470AD4-6	RIVET, PAN HEAD

△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171431

FEB 01 2018



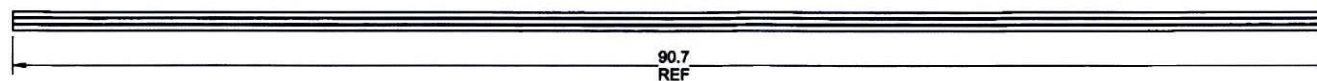
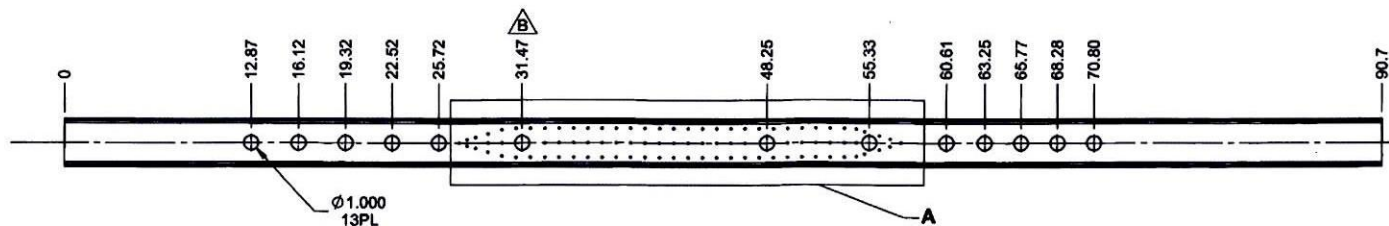
D4681-041 WEB ASSY △B

RELEASED
2013-11-13
WP

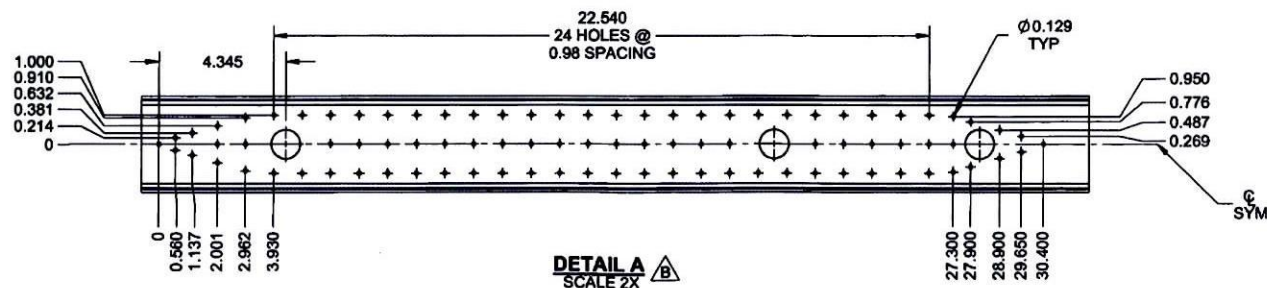
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4681-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 5.94 lbs
- 8) SEAL FAYING SURFACES WITH PROSEAL P/S 890 B-1/2 (PRC)

B	MS20470AD4-6 WAS MS20470AD4-7. ADDED DETAIL A ON SHEET 2. VARIOUS DIMENSIONAL CHANGES.	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4681 REV. B SHEET 1 OF 4 TITLE WEB ASSY SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	AP		
CHECKED	AS		
MFG. APPR.	2/		
APPROVED	2/		
DE APPR.	2/		
DATE	13.08.08		



D4681-1 WEB



DETAIL A
SCALE 2X

NOTES:

- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.74 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	<i>AS</i>	DRAWING NO. D4681	REV. B
MFG. APPR.	<i>AP</i>		SHEET 2 OF 4
APPROVED	<i>AP</i>	TITLE WEB ASSY	SCALE NTS
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DATE	13.08.08		

RELEASE
2013-11-13

